

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62386

September 29, 2010 9:17:06 AM



Page 2

Item ID: D2197-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per dwg D2196

0.00

0.00

SB 10/00/06

5

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/10/06

75
2

150



Packaging

Packaging

Identify as per dwg & Stock Location: 20

Memo

0.00

0.00

10/10/06 SF 50

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Page 3

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Setup Start



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Stop



Item Name: Bracket

Start Date: 9/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/07 *[Signature]*
MF
10-10-06

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Picklist Print

September 29, 2010 9:17:06 AM

Page 1

Work Order ID: 62386



Parent Item: D2197-2



Parent Item Name: Bracket

Start Date: 9/29/10

Required Date: 10/08/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

123.9100

0.1388

0.292211



304/316 Sheet .063

17
10-9-30

Location

Loc Qty

Loc Code

MAT

117.37

111323

0

115688

117.37

MAT20

6.54

115440

6.54

115688

5

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DART AEROSPACE LTD		Work Order:	62386
Description: Bracket		Part Number:	D2197-2
Inspection Dwg: D2197	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	*		V 1800	
Ø0.203	+0.005/-0.001	.205	✓		V	
Ø0.257	+0.006/-0.001	.257	✓		V	
0.300	+/-0.010	.300	✓		V	
0.375	+/-0.010	.377	✓		V	
0.500	+/-0.010	.500	✓		V	
1.200	+/-0.010	1.204	✓		V	
2.390	+/-0.010	2.394	✓		V	
3.280	+/-0.010	3.284	✓		V	
4.480	+/-0.010	4.479	✓		V	
4.980	+/-0.010	4.980	✓		V	
0.500	+/-0.010	.500	✓		V	
0.813	+/-0.010	.815	✓		V	
1.750	+/-0.010	1.751	✓		V	
2.688	+/-0.010	2.688	✓		V	
3.625	+/-0.010	3.629	✓		V	
4.000	+/-0.010	4.005	✓		V	
0.063	+/-0.010	.059	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-30	Date: 10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	

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DART

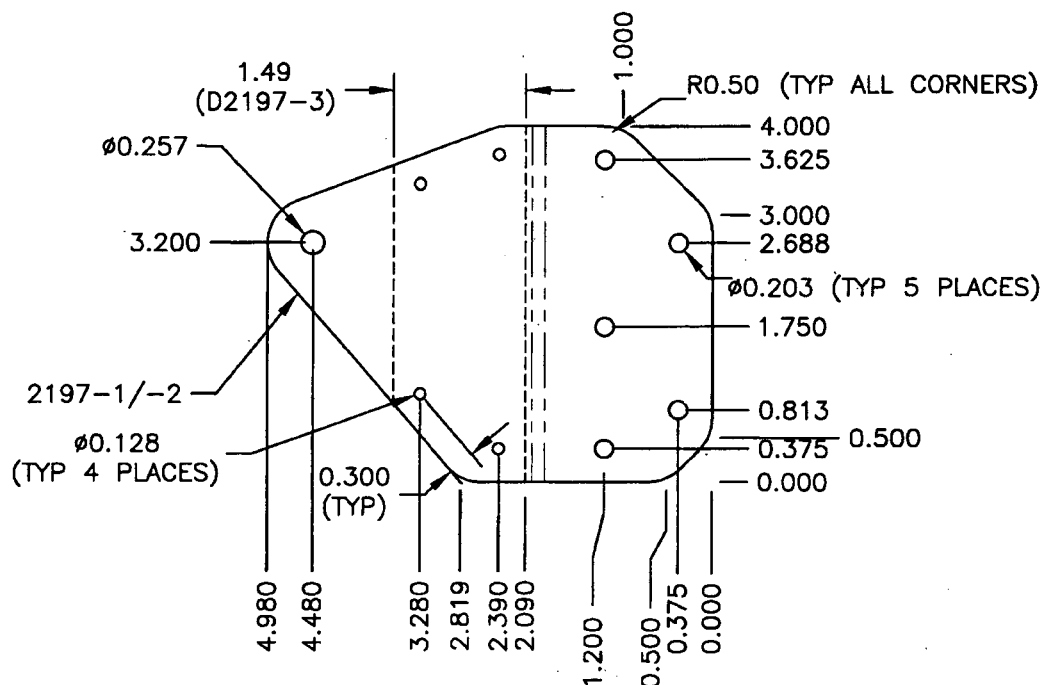
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

RELEASED
03.07.09 *[Signature]*

UNDER REVIEW

[Signature] 03.11.12
NCR/08-110
OK *[Signature]* 10.08.28

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

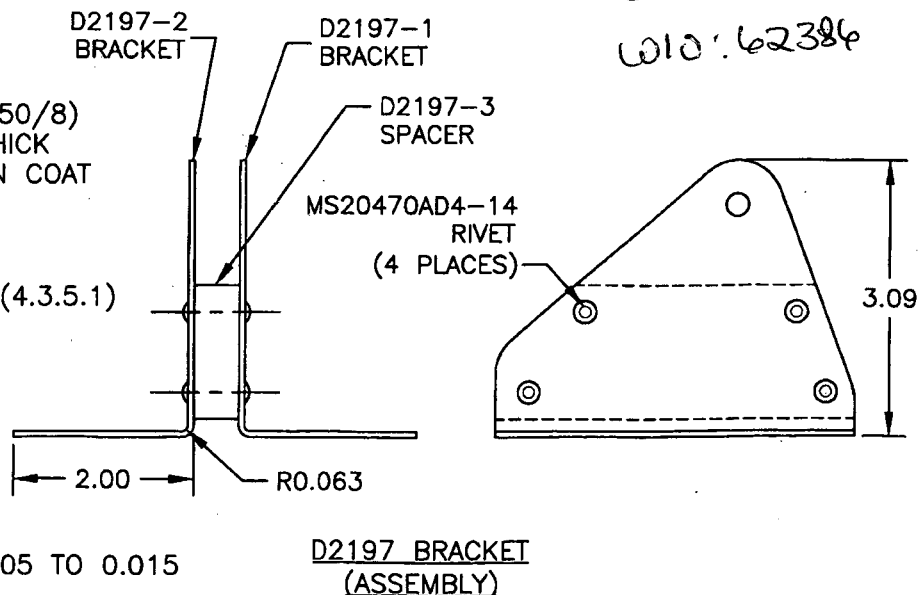
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2197 BRACKET
(ASSEMBLY)

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